



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400315
Job Sheet 184983



Part No: RBT400315

Job Qty: 1 ea

Part Name: Main Transmission Backlash Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400315 Rev 0 IPP Rev 0 18.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/9/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		11/9/18	0.00	0.25	Small Fab-3		MLC DAS
120	QC	1 pcs		11/9/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/9/18	0.00	0.00	Packaging3-1		MLC 9-89
140	QC21-SA	1 Ea		11/9/18	0.00	0.00	QC21		NOV 15 2018

Part Op Descriptions: 110 - 1-Press in dowel pin as per DWG. view A-A. 2-Assemble as per DWG.

DAS
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91083A032	Flat Washer	2 Ea (2 ea)	90-Start up Operation	5048592
94846A520	Hex Nut	1 Ea (1 ea)	90-Start up Operation	5048593
98381A216	Dowel Pin	1 Ea (1 ea)	90-Start up Operation	5048591
RBT400315-1	Weldment	1 Ea (1 ea)	90-Start up Operation	5069856
RBT400315-7	Bolt	1 Ea (1 ea)	90-Start up Operation	5069188

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91083A032	2	103	0
	94846A520	1	49	0
	98381A216	1	99	0
	RBT400315-1	1	3	0
	RBT400315-7	1	9	0



Container No: S127788



Part: RBT400315

Job No: 184983

Serial No/Batch: S127788

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ns

be found.

Plex 10/19/18 12:45 PM Dart.lajeunesse.marie

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

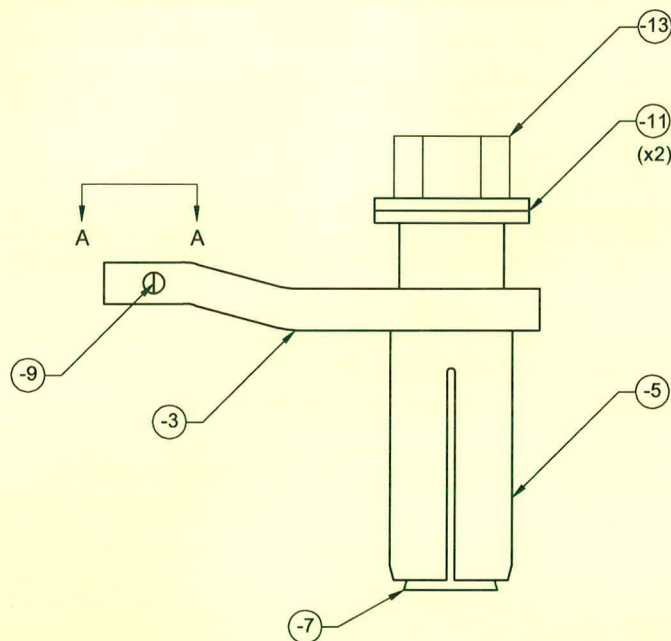
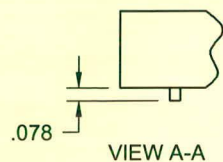
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 184983 MJS
 18-10-14

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS 1/32 METRIC REF. .XXmm ± .1mm FRACTIONS 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-11-11
SHEET 1 of 5	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	WELDMENT			2
	1		-3		ARM	A36 PLATE	1/4 x 1-1/8 x 2-7/8	3
	1		-5		COLLET	4140 Q&T	Ø3/4 x 2-1/4	4
			-7	1	BOLT	STEEL	7/16-20 UNF -2A MCMaster-CARR #91247A326 (NEEDS MOD.)	5
	B/O		-9	1	DOWEL PIN	STEEL	Ø1/8 x 5/16 MCMaster-CARR #98381A216	1
	B/O		-11	2	FLAT WASHER	STEEL	15/32 I.D. x 59/64 O.D. x .05 MCMaster-CARR #91083A032	1
	B/O		-13	1	HEX NUT	STEEL	7/16-20 UNF -2B MCMaster-CARR #94846A520	1
ASSY	-1							

